

Work Order ID 77168 *2*

November 28-11 9:00:25 AM

**\*77168\***

Page 1

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 28/11/2011 Start Qty: 4.00

Required Date: 12/12/2011 Req'd Qty: 4.00

Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: *M.L.J.*

QC:

Date: *11/11/22*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3779

Rev A

100

**\*100\***

Waterjet

FLOW CNC Waterjet

*600 377*

FLOW WATER JET

Memo

1-Cut D3779-5 as per Dwg D3779

Dwg Rev: *1A*

Prog Rev: *1A*

2-Deburr if necessary

0.00

0.00

*B11-17-22*

110

**\*110\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*B31-17-22*

120

**\*120\***

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*Split 11/2/22*

*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77168

November-28-11 9:00:25 AM

**\*77168\***

Page 2

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 28/11/2011 Start Qty: 4.00

Required Date: 12/12/2011 Req'd Qty: 4.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

**\*130\***

Small Fab

Small Fab

Small Fab

Memo

1- counter sink holes as per dwg D3779  
2- deburr

0.00

0.00

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

**\*150\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

*Handwritten signature and date 11/12/20*

*Handwritten signature and date 11/12/23*

*Handwritten signature and date 11-12-23*

*Handwritten circled number 4*

*Handwritten circled number 4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 77168

November-28-11 9:00:25 AM

**\*77168\***

Page 3

Item ID: D3779-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Handle Assembly (Interior)

Start Date: 28/11/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

4  
accept 4 11/12/11

180

Small Fab

0.00

**\*180\***

Small Fab

Memo

0.00

Small Fab

1- rivet D3203-1 handle to D3779-5 plate as per dwg D3779 per QS1003

SB 12/01/03

(2)

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

Memo

0.00

Quality Control

8/2/10/03



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 77168**

November-28-11 9:00:25 AM

**\*77168\***

Page 4

Item ID: D3779-043

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Handle Assembly (Interior)

Start Date: 28/11/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

200

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*200\***

Packaging

Memo

PAP 77166  
SHIP

0.00

Packaging

12/1/04 (2)

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

OK 12/01/05  
MF 12-01-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



9:00:29 AM

Order ID: 77168

\*77168\*

Parent Item: D3779-043

\*D3779-043\*

Parent Item Name: Handle Assembly (Interior)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec  
 IPP Rev:B 08-07-21 procedure change DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S 125		Purchased	No			106	sf	84.7400	0.4365	1.837895			
									**				
*M6061T6S 125* 6061-T6 125 Sheet													

Location	Loc Qty	Loc Code
MAT009	4.9	
119513	4.9	
MAT021	79.84	
113608	65.35	
118217	14.49	

D3203-1  
 Handle

\*D3203-1\*

Manufactured No

180 Each 39.0000 1 4

\*\*

Location	Loc Qty	Loc Code
ST240	39	
65003	1	
69020	8	
73552	30	

MS20426AD10-8  
 Rivets

\*MS20426AD10-8\*

Purchased No

180 Each 247.0000 4 16

\*\*

Location	Loc Qty	Loc Code
ST318	247	
109681	197	
110153	50	

K1 105/110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

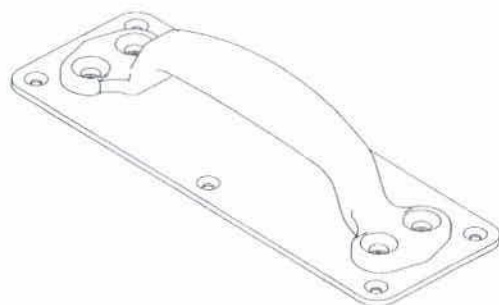
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

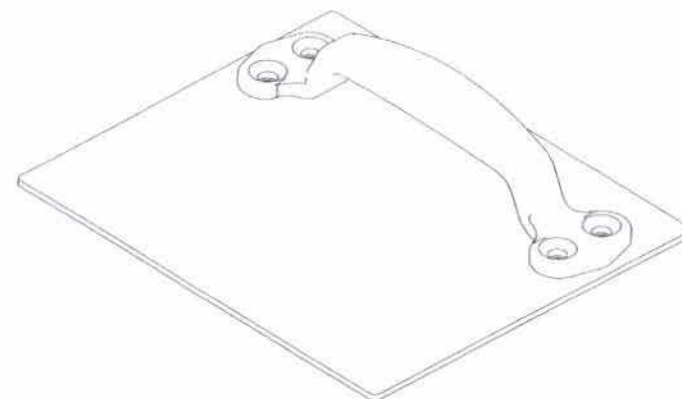
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426A010-8	RIVET, CSK



**D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)**



**D3779-3 DOUBLER PLATE**



**D3779-043 HANDLE ASSEMBLY  
(INTERIOR)**

**RELEASED**  
08.06.21

A	NEW ISSUE	DESCRIPTION	AJS	08.04.21
REV.			BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3779</b> TITLE <b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b> SCALE <b>NTS</b> COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS ISSUED AND NOT BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISSEMINATED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		
DRAWN	AJS			
CHECKED				
MFG. APPR				
APPROVED		REV. A		
DE APPR		SHEET 1 OF 4		
DATE	08.04.21			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

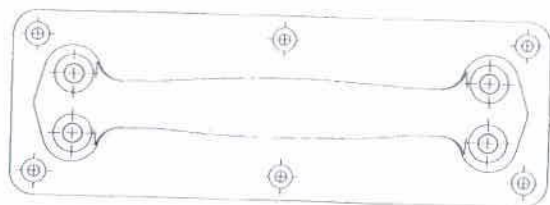
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

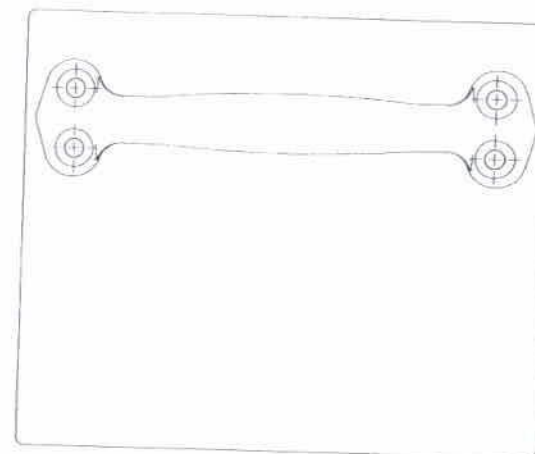
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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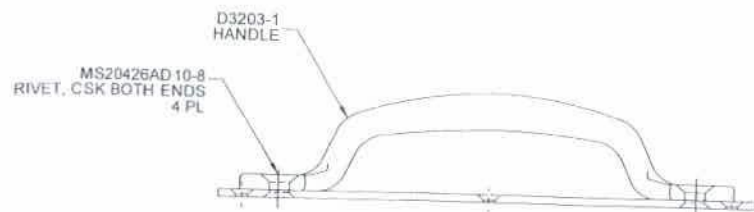
771108



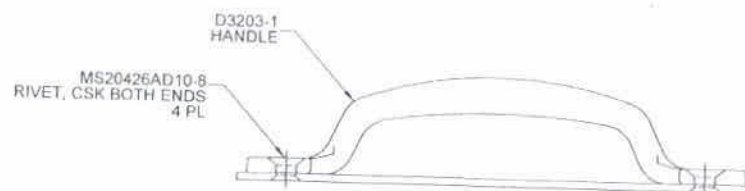
D3779-1  
PLATE



D3779-5  
PLATE



**D3779-041 HANDLE ASSEMBLY**  
(EXTERIOR)



**D3779-043 HANDLE ASSEMBLY**  
(INTERIOR)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

**RELEASED**  
08-06-26-18

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG APPR		D3779	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR		<b>HANDLE ASSEMBLY,</b> <b>CABIN SLIDING DOOR</b>	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES OF THE CONTRACT OR COMMUNICATIONS TO WHICH IT WAS PRODUCED AND NOT BE LOANED, REPRODUCED, COPIED, OR IN ANY MANNER DISSEMINATED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

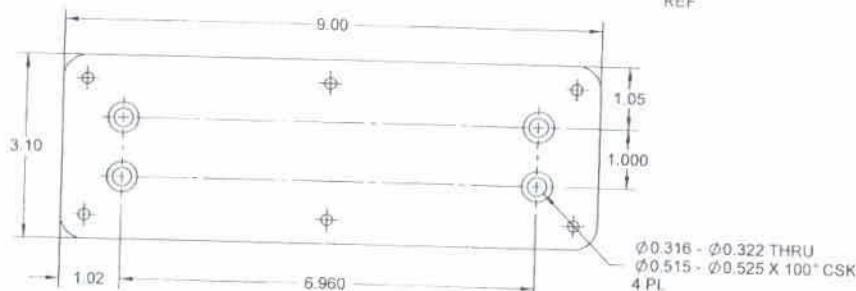
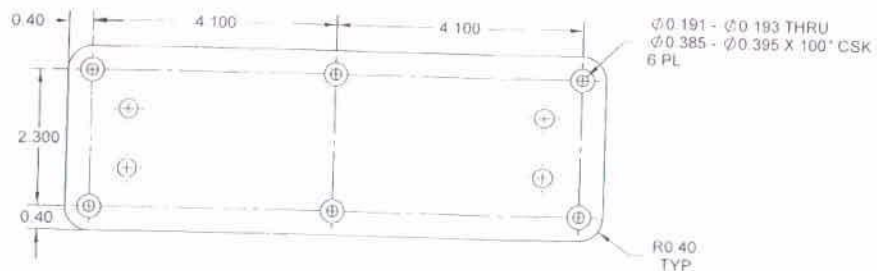
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

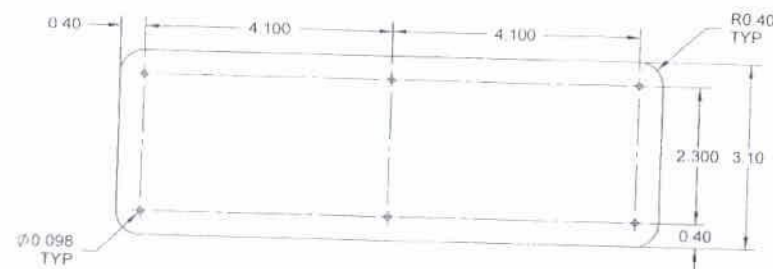
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

77160



**D3779-1 PLATE**



**D3779-3 PLATE**

**NOTES:**

- 1) MATERIAL: -1 PLATE  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.125
- 3 PLATE  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER  
(DO NOT IDENTIFY -1 & -5)
- 7) WEIGHT: 0.14 lbs FOR -3.

RELEASED  
03-05-26/10

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED			DRAWING NO.	REV. A
MFG APPR			D3779	SHEET 3 OF 4
APPROVED			TITLE	SCALE
DE APPR			HANDLE ASSEMBLY CABIN SLIDING DOOR	NTS
DATE	08.04.21		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISCLOSURE OR REPRODUCTION OF THIS DOCUMENT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD IS PROHIBITED.</small>	

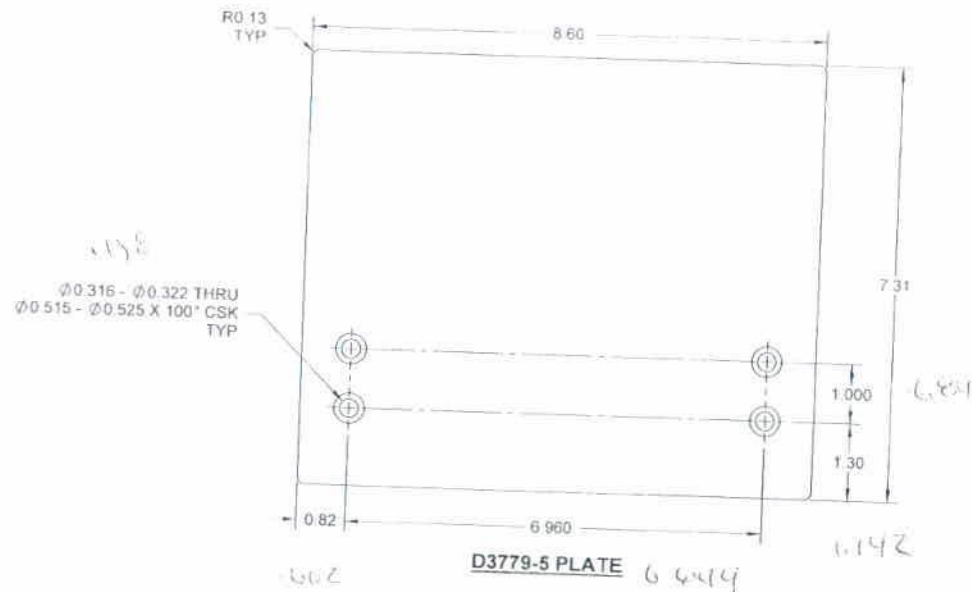
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**NOTE:** Date & initial all entries



## NOTES

- 1) MATERIAL: -5 PLATE:  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6031T6S 125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

RELEASED  
MAR 06 26 1970

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3779</b>  TITLE <b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b>  COPYRIGHT © 2006 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR DISCLOSED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV A
DRAWN	AJS		SHEET 4 OF 4
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.04.21		

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**NOTE:** Date & initial all entries



Rev	Date	Change	New Issue
1	11-12-22		
Measured by:	Date:	Audited by:	Date:
B	11-12-22	S	11-12-22
Prototype Approval:	Date:	Revised by:	Approved
		KJLM	

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Ø 316	4.006 - 4.011	±0.005	316	✓		BC	
8.60	4.030	±0.030	8.613	✓		Plus 3.2	
7.31	4.130	±0.030	7.320	✓			
1.008	4.110	±0.010	1.008	✓			
1.320	4.130	±0.030	1.301	✓			
6.966	4.110	±0.010	6.958	✓			
1.02	4.130	±0.030	1.025	✓			
1.05	4.110	±0.010	1.025	✓			

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☒ Prototype

Inspection Dwg: D3771-5	Rev: 5
Part Number: 64-3774-043	Work Order: 7116
Description: HANKE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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